

# Work Order ID 63020



Page 1

Monday, October 18, 2010 9:08:00 AM

Item ID: D3929-042

Accept



Setup

Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 10/18/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

*H*

Date: 10/10/18

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3929	A	
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100



Waterjet

FLOW CNC Waterjet

Memo

0.00

*10-10-18*

1-Cut as per Dwg D3929

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*(L)*

110



QC

Memo

0.00

*10-10-19*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes. No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

QC8- Inspect parts - second check

0.00

6

Quality Control

140



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M114649

150



QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63020**

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Start Date: 10/18/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S. Blum (S)

(76)

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WA

0.00

0.00

SAO

10/11-03

(6)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/11/04 (J)

MF  
10.11.3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

# Picklist Print

Monday, October 18, 2010 9:08:04 AM

Page 1

Work Order ID: 63020



Parent Item: D3929-042



Parent Item Name: Gusset Assembly

Start Date: 10/18/2010

Required Date: 10/26/2010

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	56.7523	0.45	2.842105		10/10/18	

304/316 0.125 Sheet

D3907-1



Bushing

Manufactured

No

Location	Loc Qty	Loc Code
MAT	56.7523	
114799	56.7523	

130 Each 45.0000

2

12

(6)

14744

10/11/03

Location	Loc Qty	Loc Code
WA	45	
60720	5	
62149	40	

(12x)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	63020
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

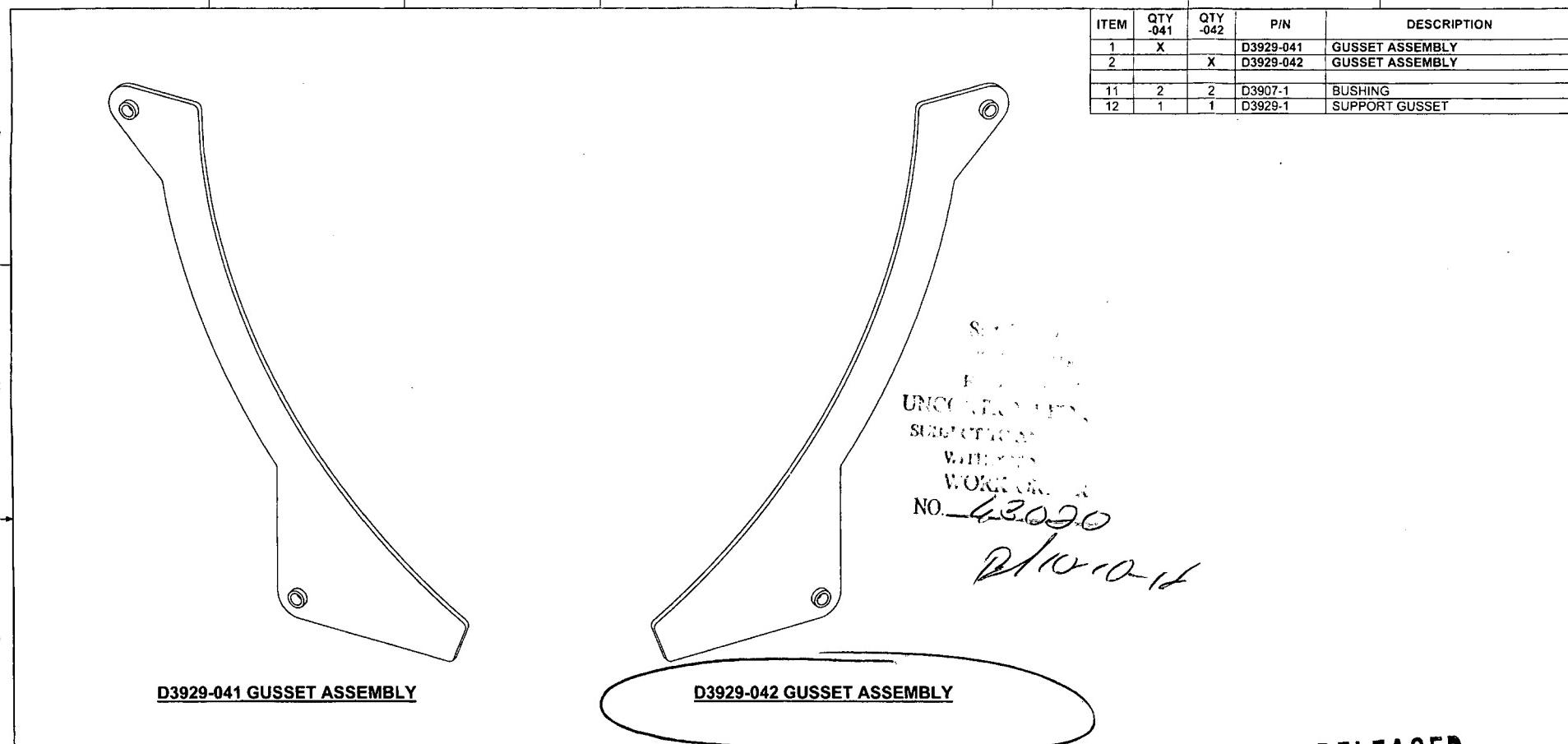
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

Measured by:	<u>RB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>10-10-19</u>	Date:	<u>10/10/19</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue P/O D3929-041/-042	KJ	

8 7 6 5 4 3 2 1



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.73 lbs EACH  
 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

A	REV.	NEW ISSUE	MB	09.04.03
DESIGN		DESCRIPTION	BY	DATE
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3929		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		GUSSET ASSEMBLY		NTS
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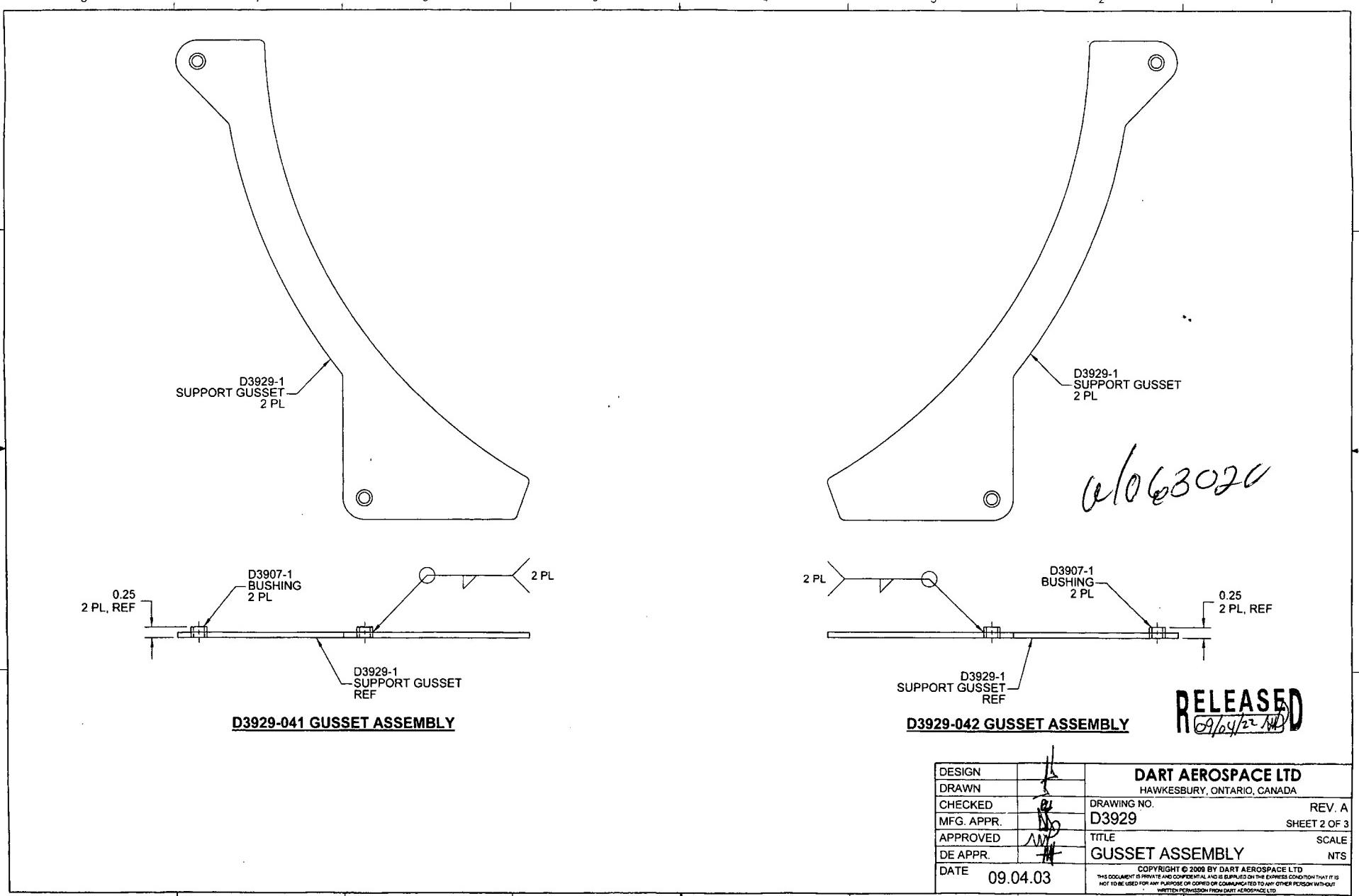
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD			
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[Signature]</i>	DRAWING NO.			
MFG. APPR.	<i>[Signature]</i>	D3929			
APPROVED	<i>[Signature]</i>	REV. A			
DE APPR.	<i>[Signature]</i>	SHEET 2 OF 3			
DATE	09.04.03	TITLE			
		SCALE			
		GUSSET ASSEMBLY			
		NTS			
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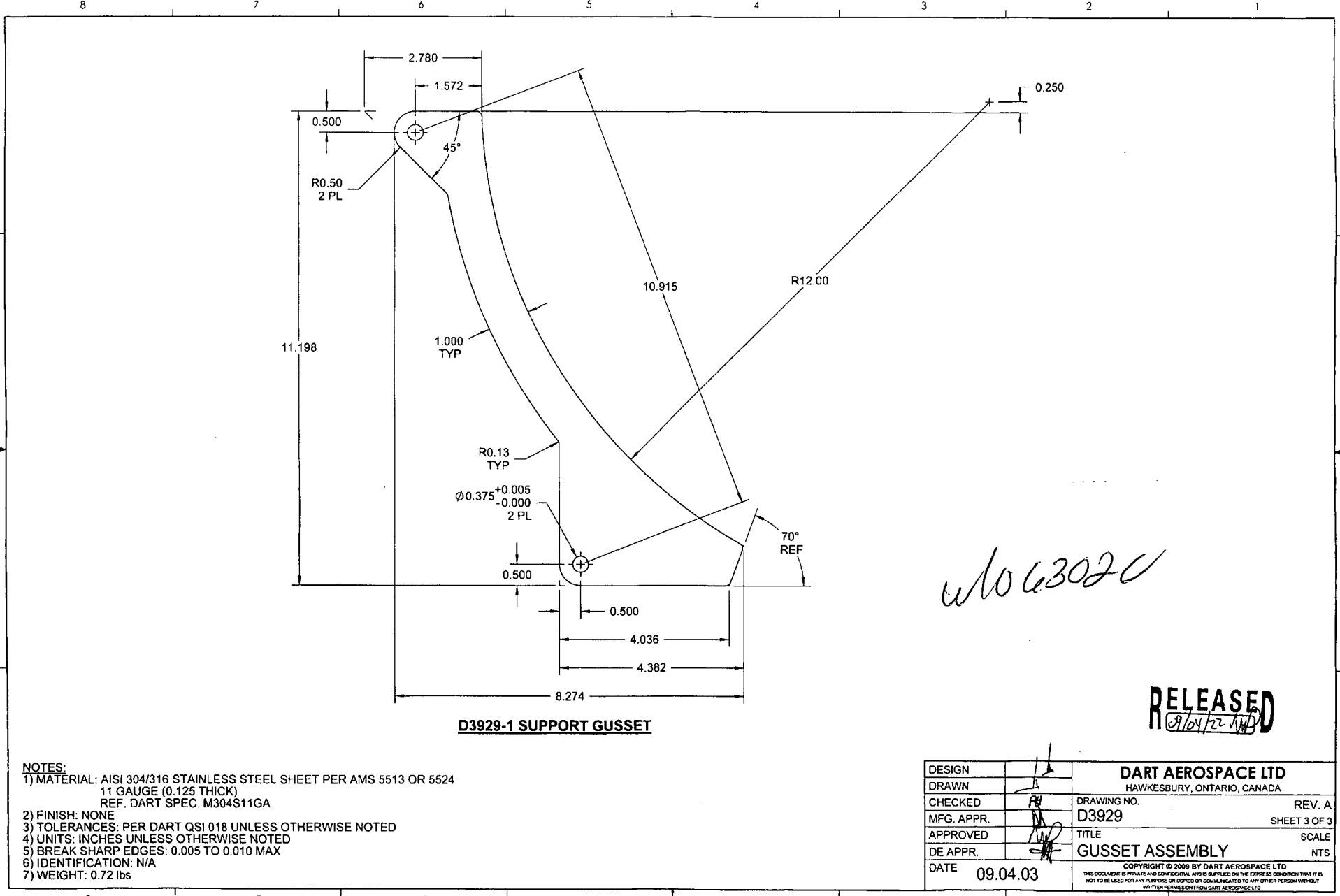
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